

Work Order ID 67361



Page 1

Wednesday, March 16, 2011 12:05:35 PM

Item ID: D3772-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Leg

Start Date: 3/16/2011

Start Qty: 10.00



Cust Item ID:

Required Date: 3/23/2011

Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-03-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3772

Rev A

6X

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 31.500" long

= 7m-L 11/03/17

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA787 Rev: AA & Dwg D3772 Rev: A

B.A 11/04/05

6

0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B.A 11/04/05

6

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 3/16/2011 Start Qty: 10.00

Required Date: 3/23/2011 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

ml 11/04/05

6

QC

Memo

0.00

Quality Control

140

Small Fab

0.00

6x

Small Fab

Memo

0.00

Small Fab

1-cut tube to length as per dwg D3772 2- deburr 3-bend tube as per dwg D3772

⇒ m-l 11/04/11

150

QC5- Inspect part completeness to step on W/O

0.00

ml

11

04

12

6

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Item ID: D3772-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Leg

Start Date: 3/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Packaging

Identify as per dwg & Stock Location 254

0.00

Memo

0.00

Packaging

11/4/14 sf62

170



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

11/4/18 AFmt
11-04-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Picklist Print

Wednesday, March 16, 2011 12:05:40 PM

Page 1

Work Order ID: 67361



Parent Item: D3772-1



Parent Item Name: Back Leg

Start Date: 3/16/2011

Required Date: 3/23/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-06-18 rev.A as per dwg DD verified by:EC
IPP Rev:B 08-09-24 Now on Haas JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR1.250W.125

Purchased

No

110

f

24.7500

2.6252

27.63368



304 RD Tube 1.250 x .125w

M-1 11/03/17

Location

Loc Qty

Loc Code

MAT037

24.75

113494

4.75

114812 ✓

20

16-5802

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 67361
Description: BACK LEG		Part Number: D3772-1
Inspection Dwg: D3772 Rev: A		Page 1 of 1

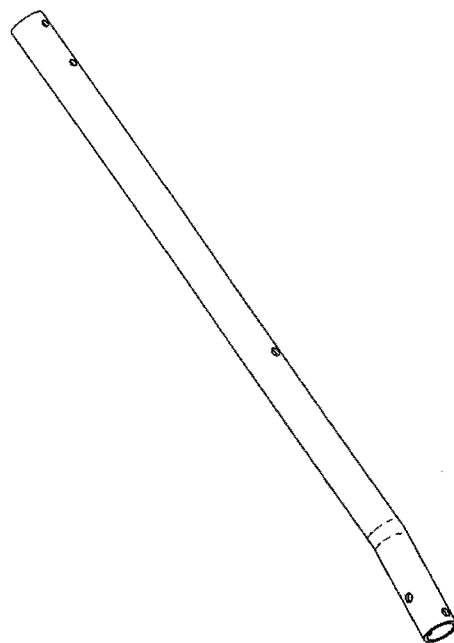
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50	+/- .030	0.495	✓		Vern	GA-01
1.70	+/- .030	1.700	✓		"	"
12.56	+/- .030	12.560	✓		Tape	GA-12
22.00	+/- .030	22.000	✓		"	"
φ 0.257	+ .006 / - .001	φ 0.259	✓		Vern	GA-01
φ 0.323	+ .006 / - .001	φ 0.325	✓		"	"
φ 0.323	+ .006 / - .001	φ 0.325	✓		"	"
1.10	+/- .030	1.100	✓		H+G	31006
φ 0.323	+ .006 / - .001	φ 0.325	✓		Vern	GA-01
10°	+/- 1/2°					
0.61	+/- .030					
3.75	+/- .030					
0.38	+/- .030					

Measured by: BA	Audited by: <i>[Signature]</i>	Prototype Approval:
Date: 11/04/05	Date: 11/04/05	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3772-1 BACK LEG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 6-7364
PL 11-03-16

RELEASED
08-06-16

NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBING 1.25" OD X 0.125" WALL (REF DART SPEC M304TR1.25W.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.26 lbs

A	NEW ISSUE	HS	08.06.03
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3772	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BACK LEG	NTS
DATE	08.06.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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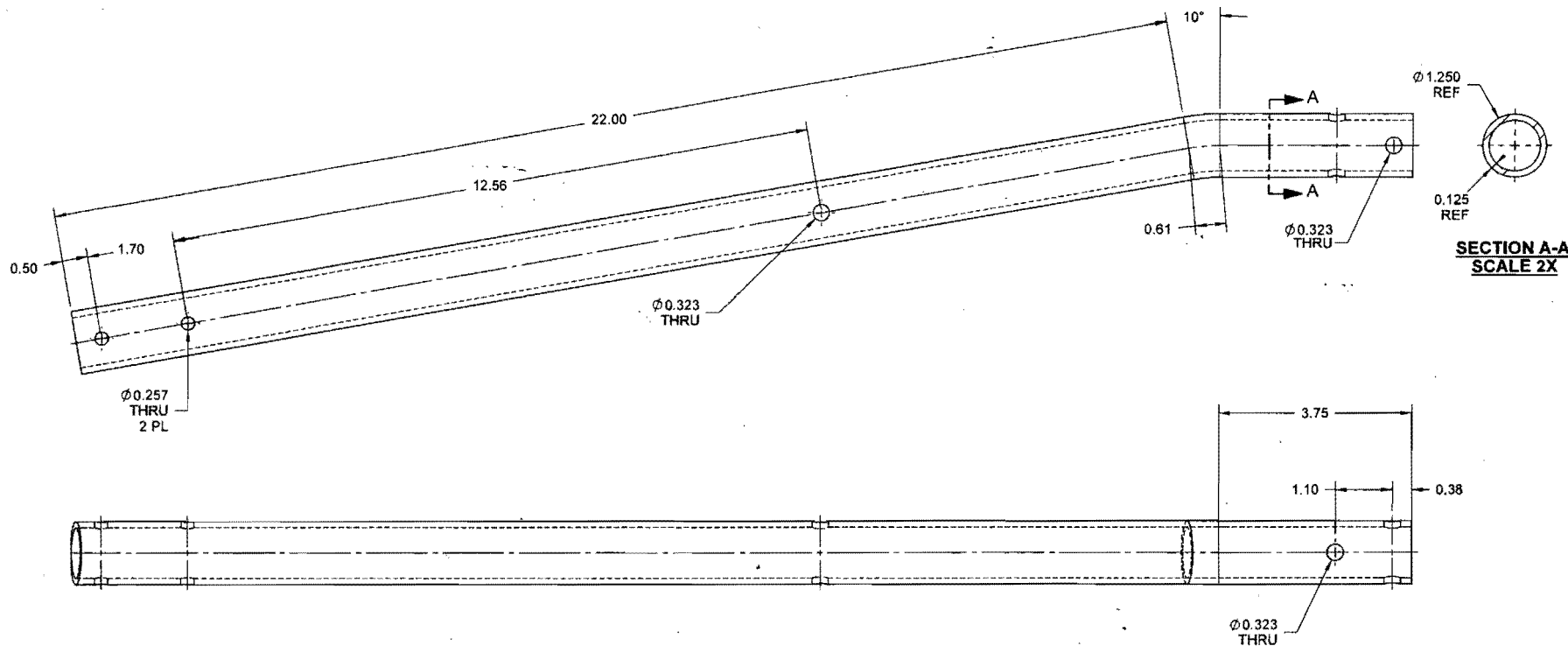
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W1067301



SECTION A-A
SCALE 2X

RELEASED
08-06-14

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	PS	DRAWING NO.	REV. A
MFG. APPR.	AA	D3772	SHEET 2 OF 2
APPROVED	AA	TITLE	SCALE
DE APPR.	AA	BACK LEG	NTS
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Dart Aerospace Ltd

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